

Work Order ID 58382

May 5, 2010 9:21:51 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 5/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DC

DOCUMENT CONTROL

0.00

Memo

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A pulled into W/O 58652

Document Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58382

May 5, 2010 9:21:51 AM



Item ID: D412:742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 5/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



HandFinishing

HandFinish

Hand Finishing

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/R: ||| Sikaflex-241/-291 ||| M113519
Expiry date: || 10/11

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R: ||| Sikaflex-241/-291 ||| M113519
Expiry date: || 10/11

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R: ||| LPS Procyon ||| M104251

⇒ M 10/07/07 1 q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-742-043 PAR #: _____ Fault Category: Skid tubes NCR: Yes ~~No~~ DQA: 1 Date: 10/07/08
 Resolution: re-work Disposition: re-work QA: N/C Closed: Chen Date: 10/07/08

NCR: 58382		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.07.07	1/10	Fuel saddle hole won't allow bolt to be installed.	CP 10.07.07 98/442	Acceptable to file inner hole to allow bolt to install → 0.008" - inner edge	all 10/07/07	S 10/07/08	CP 10.07.07 98/442	S 10/07/08
		RL: REWORK						

NOTE: Date & initial all entries

Work Order ID 58382

May 5, 2010 9:21:52 AM



Page 3

Item ID: D412-742-043

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 5/05/10 Start Qty: 1.00

Required Date: 5/12/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

120



QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

81267100

10

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

0.00

0.00

PPP 58652

10-7-8

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

1007-08
mf
10-7-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 5, 2010 9:21:49 AM

Page 1 / 3

Work Order ID: 58382

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 5/05/10

Required Date: 5/12/10

Comments: IPP Rev A: 05.10.13 New Issue: KJ/JLM: EC
 IPP Rev B: 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev C: 07-05-28 As per Rev F JLM
 IPP Rev D: 07-12-04 ECN 1072 DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 110 Each 2,029.000 24



BOLT

Location Loc Qty Loc Code

ST350 2029
 114103 501
 114108 300
 114416 228
 114523 1000

~~351672~~ x24 of 10/07/07
 11414859

AN3C6A Purchased No 110 Each 581.0000 12



BOLT

Location Loc Qty Loc Code

ST351 581
 11982 581

x12 of 10/07/07

AN3C7A Purchased No 110 Each 269.0000 8



BOLT

Location Loc Qty Loc Code

ST351 269
 113149 169
 114382 100

x8 of 10/07/07

AN960C10L Purchased No 110 Each 0.0000 44



washer

D3391-021



Fwd Tube Assembly

NAS1149C0332R / 115000

Manufactured No 110 Each 0.0000 1

A- used on #56491 D3391-023

~~356214~~

x44 of 10/07/07

x1 of 10/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 5, 2010 9:21:49 AM

Work Order ID: 58382

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev C 07-05-28 As per Rev F
IPP Rev D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by:JLM

Start Date: 5/05/10

Required Date: 5/12/10

Start Qty: 1.00

Required Qty: 1.00

D3391-023 Manufactured No

110 Each

1.0000



Mid Tube Assembly

Location

Loc Qty

Loc Code

FP

40522

B56491

1

110

Each

1.0000

X1 21 10107107

D3391-025 Manufactured No



Aft Tube Assembly

Location

Loc Qty

Loc Code

FP

48122

B56219

1

110

Each

11.0000

X1 21 10107107

D3564-1 Manufactured No



Wearshoe

Location

Loc Qty

Loc Code

FG

33798

FP

51676

2

2

9

9

110

Each

11.0000

X1 21 10107107

D3564-3 Manufactured No



Wearshoe

Location

Loc Qty

Loc Code

FG

33764

FP19

55489

2

2

9

9

X1 21 10107107

May 5, 2010 9:21:49 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 5, 2010 9:21:50 AM

Work Order ID: 58382

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 5/05/10

Required Date: 5/12/10

Comments: IPP Rev A: 05.10.13 (New Issue) KJ/JLM
IPP Rev B: 06.02.13 (ECN 773 dwg @ rev.D EC
IPP Rev: C 07-05-28 As per Rev F JLM
IPP Rev: D 07-12-04 ECN 1072 DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 110 Each 9.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FG	1	B58709
34806	1	
FP19	8	
57525	1	
57729	7	

x1 24 10/07/07

D3566-1 Manufactured No 110 Each 45.0000 2



Gasket

Location	Loc Qty	Loc Code
FP015	45	B59126
57715	24	
58182	21	

x1 24 10/07/07
x1 21 10/07/07

D3566-5 Manufactured No 110 Each 23.0000 1



Gasket

Location	Loc Qty	Loc Code
FP015	23	
57526	3	
57682	20	

x1 24 10/07/07

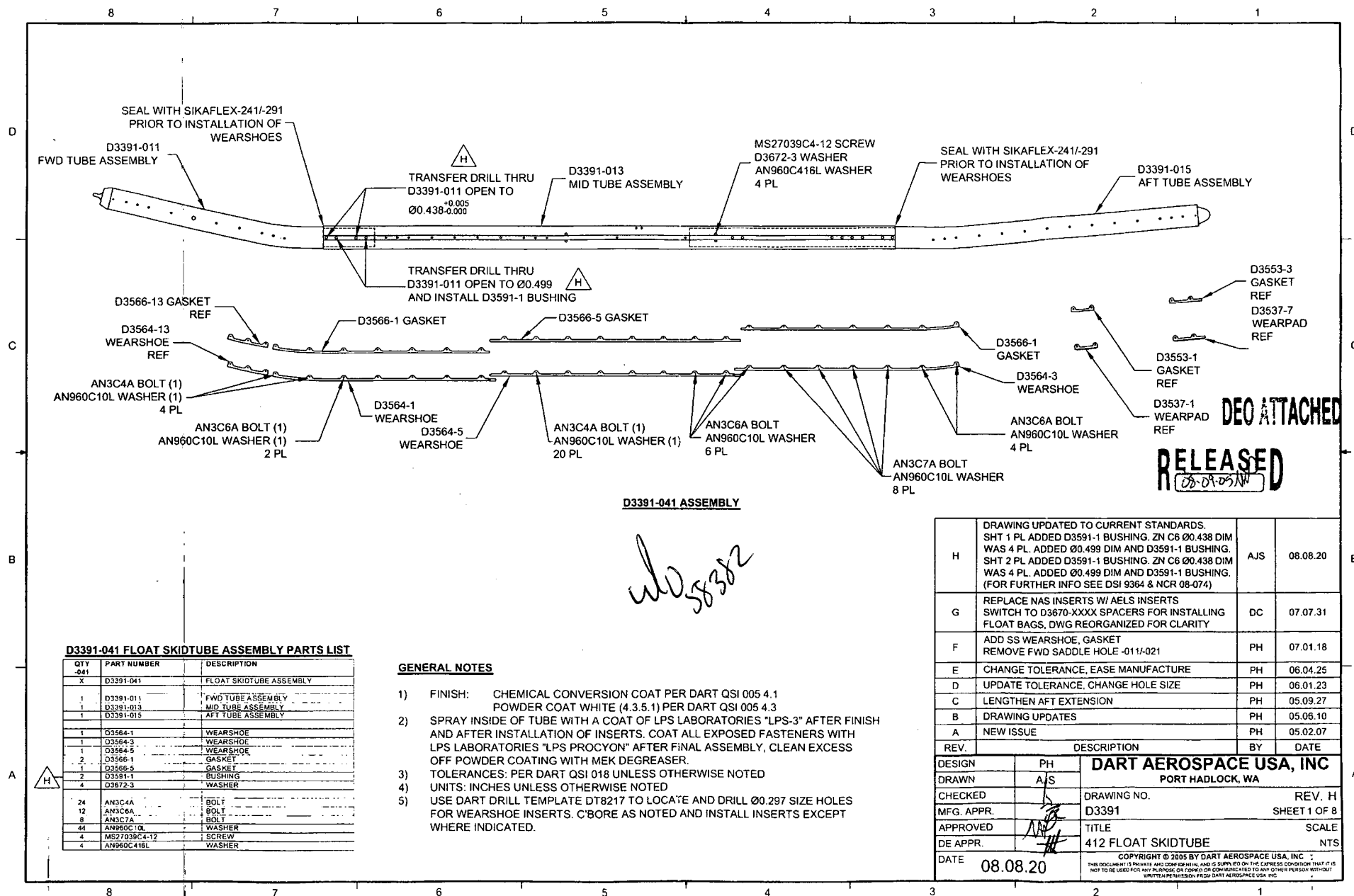
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



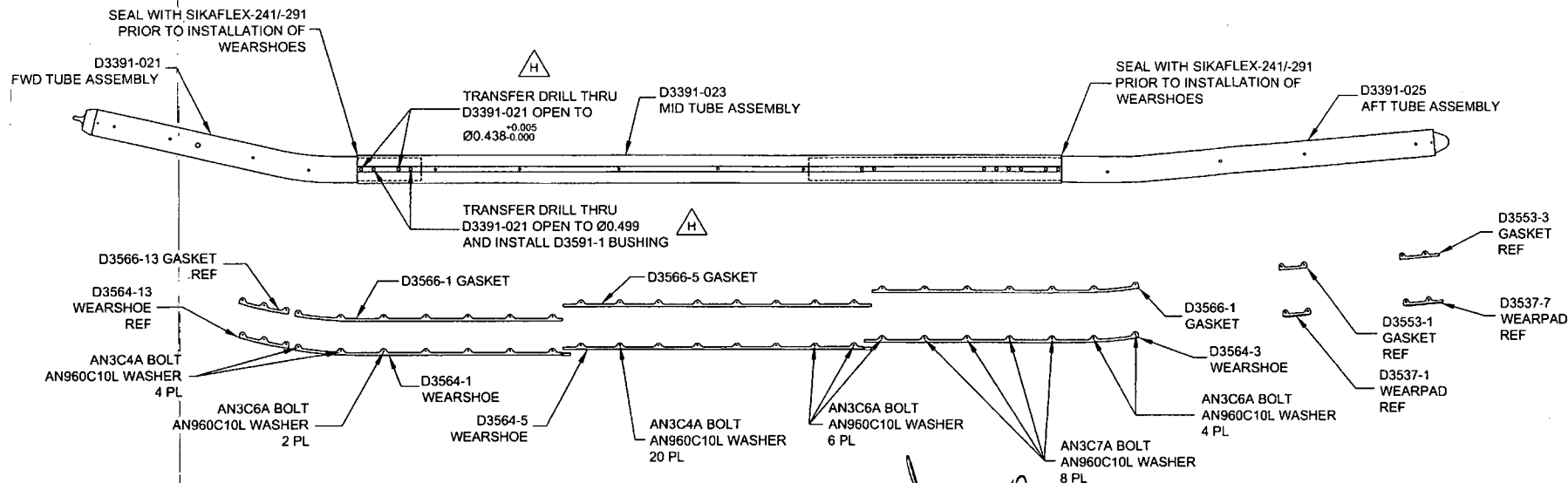
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DESIGN		PH	DART AEROSPACE USA, INC	
DRAWN		AUS	PORT HADLOCK, WA	
CHECKED			DRAWING NO.	REV. H
MFG. APPR.			D3391	SHEET 2 OF 8
APPROVED			TITLE	SCALE
DE APPR.			412 FLOAT SKIDTUBE	NTS
DATE		08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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RELEASED
08-01-05

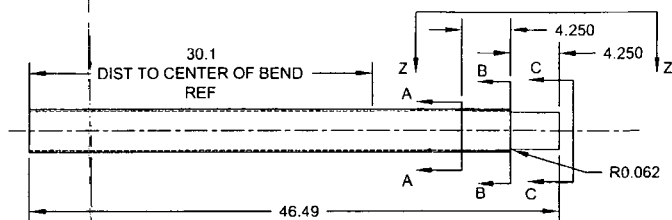
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

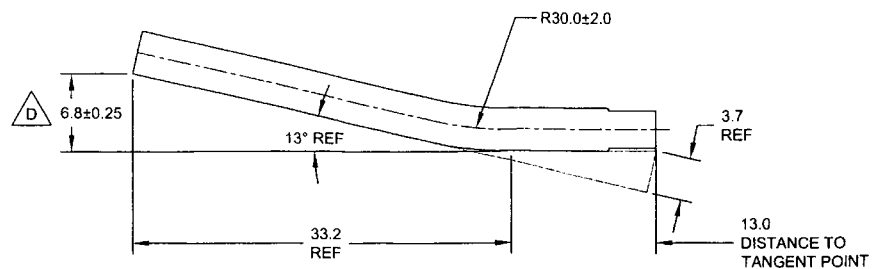
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

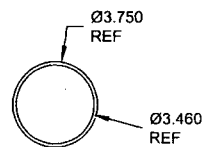
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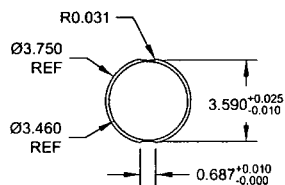
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



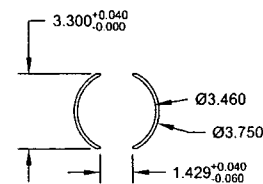
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



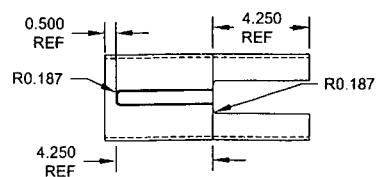
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

WLB 58352

DEO ATTACHED
RELEASED
28-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CONTAINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

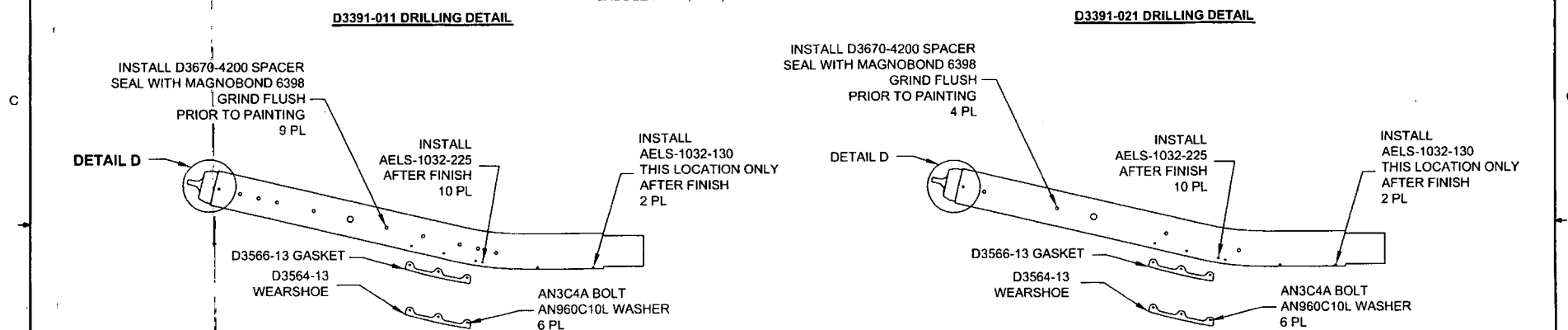
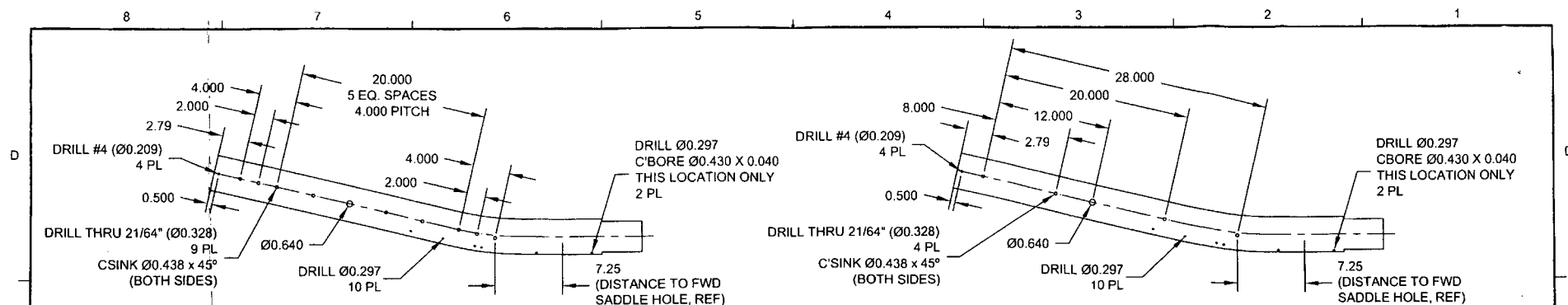
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

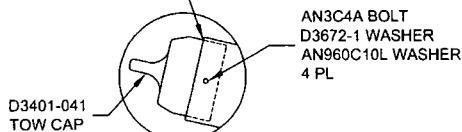
NOTE: Date & initial all entries



D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D8013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

SEAL WITH SIKAFLEX-241/-291



DETAIL D
SCALE 2X

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DESIGN PH
DRAWN AJS
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 08.08.20

DRAWING NO. D3391
TITLE 412 FLOAT SKIDTUBE
REV. H
SHEET 4 OF 8
SCALE
NTS

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DEO ATTACHED
RELEASED
08-09-2005

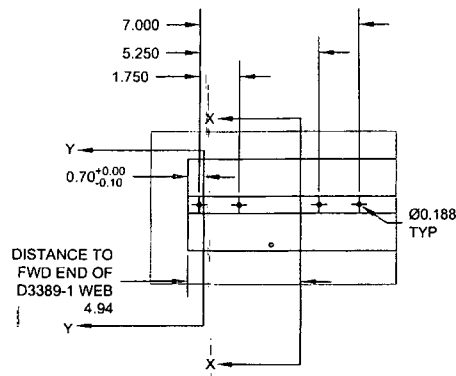
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

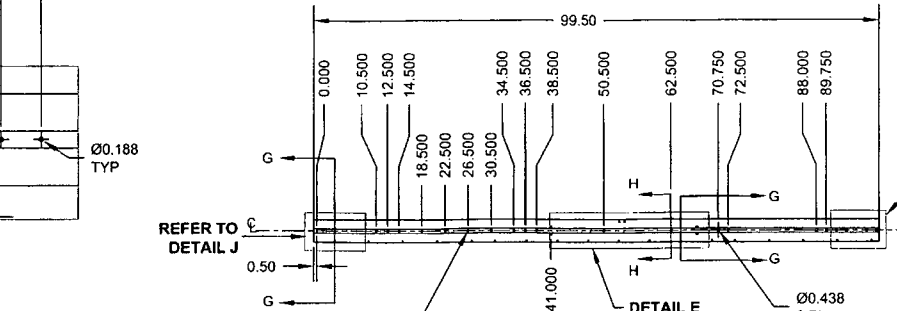
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

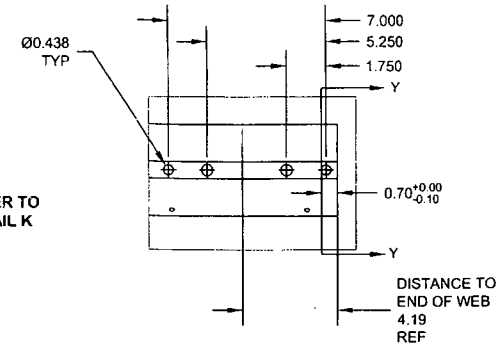
NOTE: Date & initial all entries



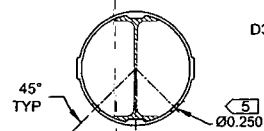
DETAIL J
SCALE 4X



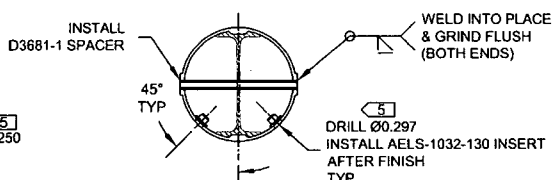
D3391-013 ASSEMBLY DETAIL



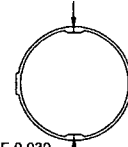
DETAIL K
SCALE 4X



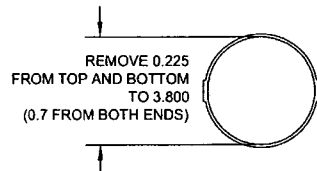
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



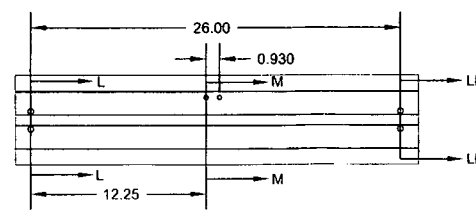
SECTION X-X
SCALE 5X



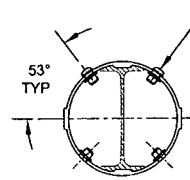
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

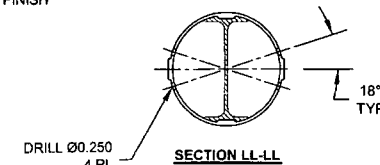


DETAIL E
SCALE NONE



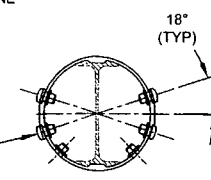
SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X

DEO ATTACHED

RELEASED

DESIGN		PH	DART AEROSPACE USA, INC	
DRAWN		AS	PORT HADLOCK, WA	
CHECKED			DRAWING NO.	REV. H
MFG. APPR.			D3391	SHEET 5 OF 8
APPROVED			TITLE	SCALE
DE APPR.			412 FLOAT SKIDTUBE	NTS
DATE		08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

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u/b 58382

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

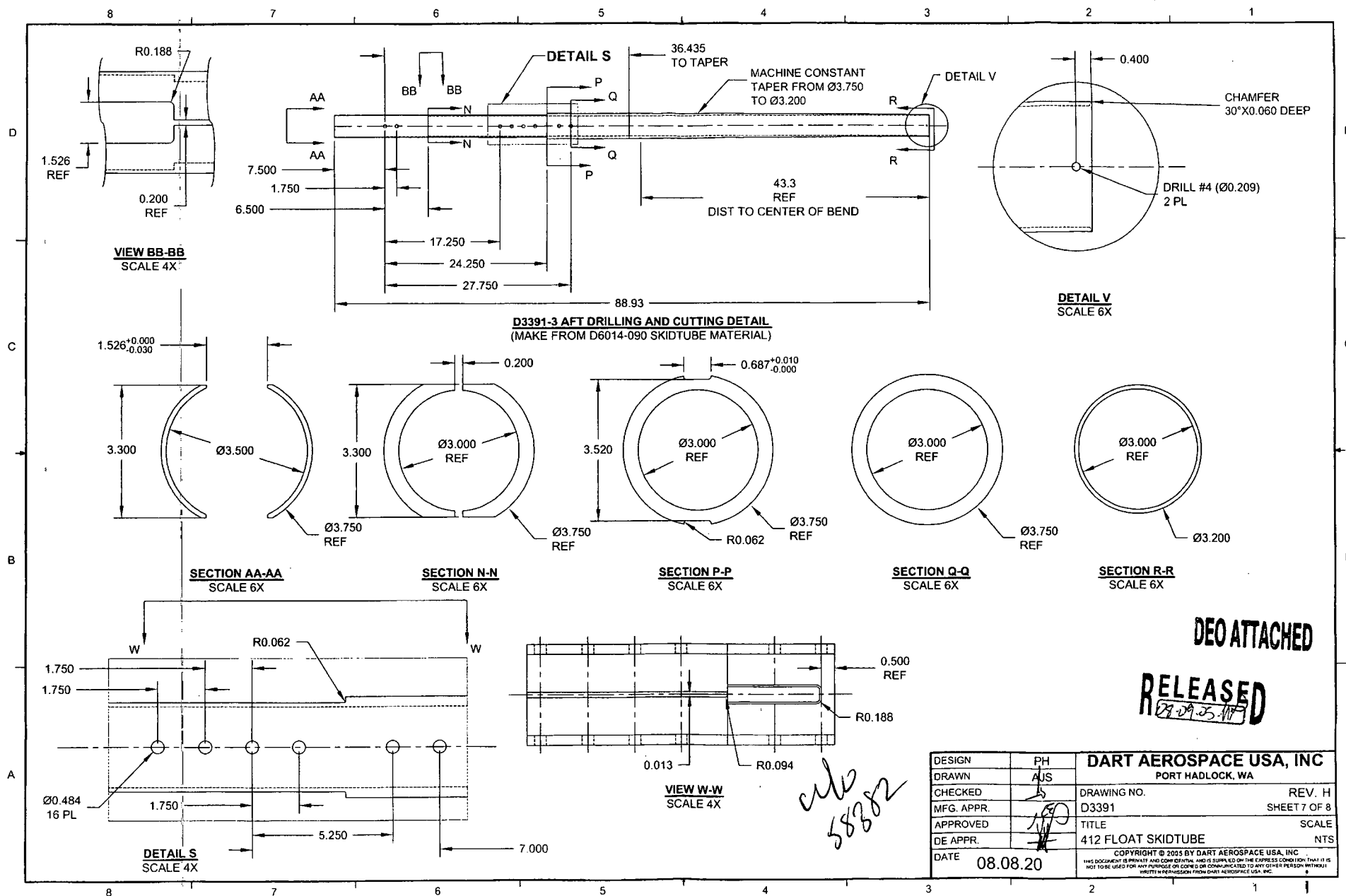
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DEO ATTACHED
RELEASED
29-09-25-117

58882

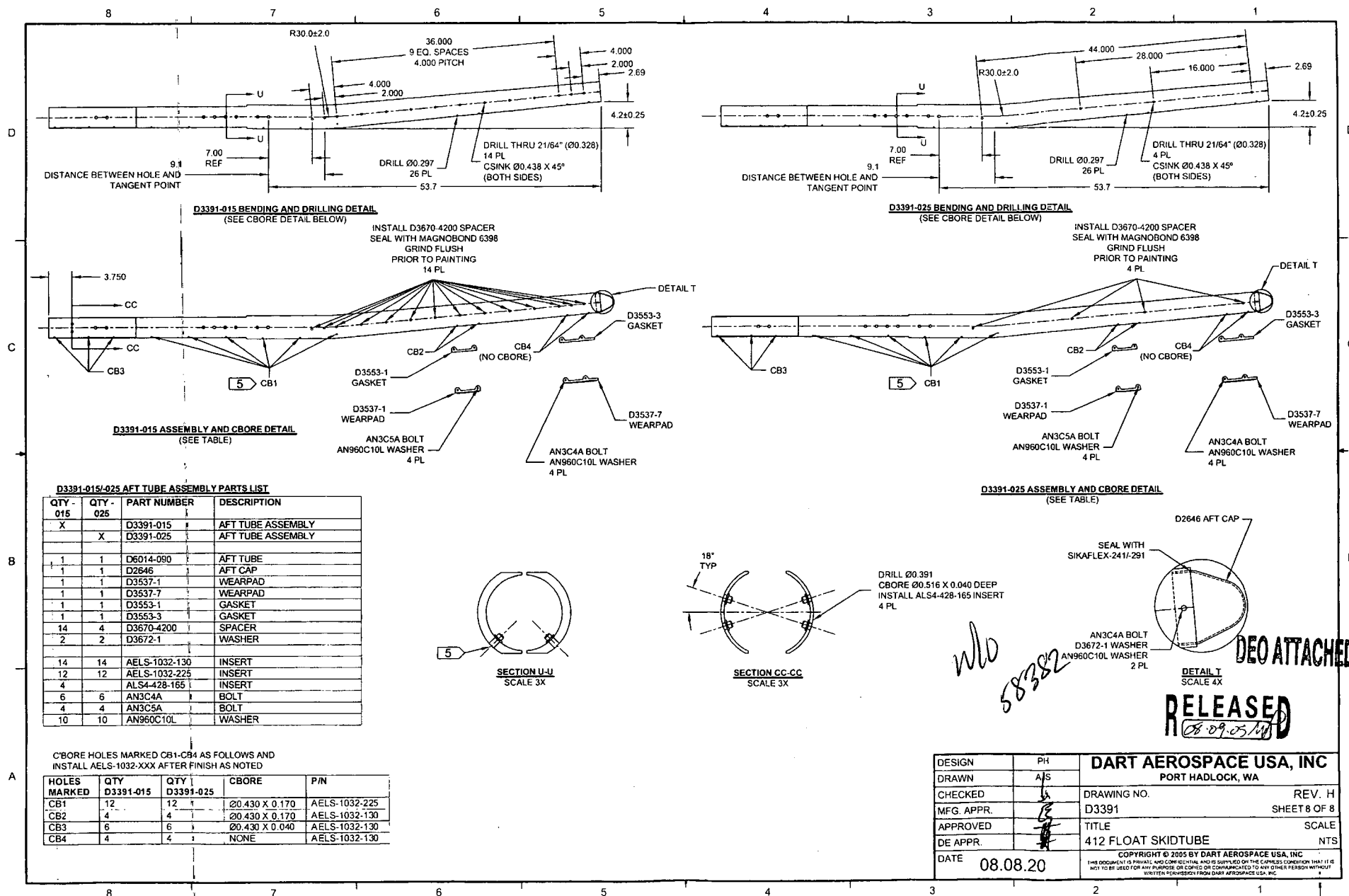
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>	DE APPR. <i>h</i>			
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30			

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02
MP

WLO 58382

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries